

November-25-11 10:52:43 AM

77101

Page 1

Accept

N900040100

Setup Start ***NS1***

Stop *NS2*

Item Name: End Bracket

Start Date: 25/11/2011 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 09/12/2011 **Req'd Qty:** 8.00

8

Customer:

Reference:

Approvals: Process Plan: *M.C-J*

Date: 11/11/25

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77101

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Item ID: D2850-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: End Bracket
 Start Date: 25/11/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00				8			
130									
QC	Memo	0.00							
Quality Control									

140	Identify as per dwg & Stock Location: <u>W14</u>	0.00				8	8		
140									
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								

150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

CK 12/7/10
 WF 12-07-09

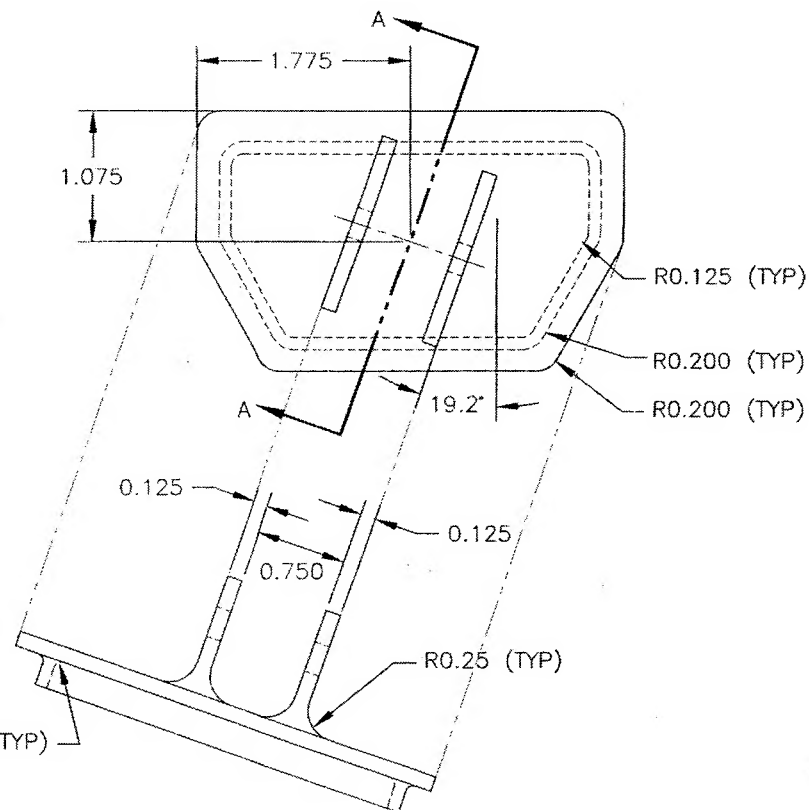
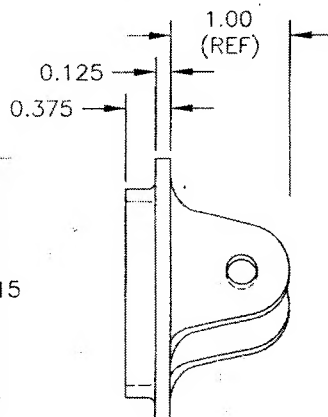
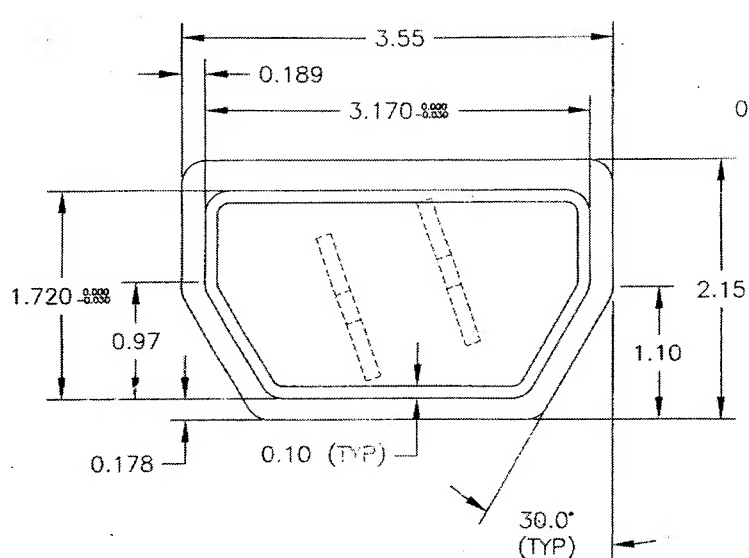
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

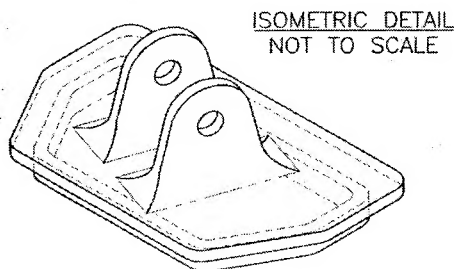


D2850-1 (SHOWN)
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

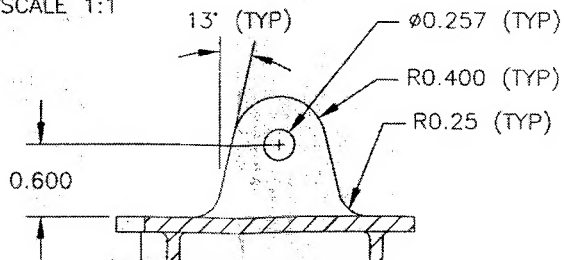
FINISH: NONE

BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL
NOT TO SCALE

SECTION A-A
SCALE 1:1



RELEASED
98/11/29
COPY 100

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN KE	DRAWN BY #	DART DART AEROSPACE LTD WARRICKBURT, ONTARIO, CANADA	REV. A
CHECKED KE	APPROVED #	DRAWING NO. D2850	SHEET 1 OF 1
DATE 98.11.10		TITLE HIGH FLOAT STEP END BRACKET	SCALE 1:1

DART AEROSPACE LTD		Work Order: 27101
Description: End Bracket		Part Number: D2850-1
Inspection Dwg: D2850 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.55	± 0.30	3.550	—		Vern H.C.H.	
.189	± 0.10	.195	—		"	
3.170	± 0.30	3.166	—		"	
1.720	± 0.30	1.716	—		"	
.178	± 0.10	.175	—		"	
.10	± 0.30	.095	—		"	
2.15	± 0.30	2.152	—		"	
.375	± 0.10	.373	—		"	
.125	± 0.10	.123	—		"	
1.00	± 0.30	.999	—		"	
.125	± 0.10	.125	—		"	
.750	± 0.10	.750	—		"	
.125	± 0.10	.1250	—		"	
R.25	± 0.30	R.250	—		R-G	
R.063	± 0.10	R.063	—		"	
.600	± 0.10	.598	—		Vern H.C.H.	
8.252	± 0.05	8.259	—		"	

Measured by: <i>onk</i>	Audited by: <i>SA</i>	Preliminary Approval:
Date: 12/07/08	Date: 12/7/8	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15